

Date: Friday, 27/10/2006 2:44:03 PM  
User: Linda Lacelle

# **Process Sheet**









<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : AFT TUBE ASSEMBLY
<b>Job Number</b> : 29211	
<b>Estimate Number</b> : 10699	
<b>P.O. Number</b> :	<b>Part Number</b> : D3391025
<b>This Issue</b> : 27/10/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3391 REV E
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : E
<b>Previous Run</b> : 29210	<b>Material</b> :
<b>Written By</b> : <u>W</u>	<b>Due Date</b> : 30/11/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manufacturing Instructions JLM	

## **Additional Product**

Job Number:



*5029*


Seq. #:	Machine Or Operation:	Description :
1.0	D6014090	ALUMINUM EXTRUSION
 		
<b>Comment:</b> Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s) ALUMINUM EXTRUSION Pick: Qty Part Number Description Batch 1 D6014-090 Extrusion <u>B26546</u> Identify as D3391-3		
		<i>MS 06/10/28 1</i>
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
 		
<b>Comment:</b> MORI SEIKI CNC LATHE LARGE Turn as per Folio FA599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>E</u>		
		<i>MS 06/10/28 1</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
		<i>MS 06/10/28 1</i>
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
 		
<b>Comment:</b> HAAS 1-Machine as per Folio FA 599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>E</u> 2-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803 3-Deburr		
		<i>P/O</i> <i>MS 07/10/03 1</i>

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/07	# 6/10	Ø.489 hole off center by 0.045" (0.0225") - wrong vice jaws used.			Ep 07/02/07			
07/02/07	# 4/10	Pilot hole off by 0.337 and one was drilled by mistake in Aft End. 3/4 more Dream drilling		See NCR 142	Ep 07/02/07			
07/02/07	# 4/10	two (2) holes are 1/2" in dia instead of 0.489" wrong drill was used by Maxine (ED)	 07/09/26	Scrap & Destroy	Ep 07/02/07	07.03.13	07/09/26	07/09/26

NOTE: Date & initial all entries

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Job Number: 29211

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(P10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EN 07/02/06

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D3391025

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

12.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0	NAS1330C3KB166	INSERT
------	----------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
8	NAS1330C3KB166	Insert	

15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per dwg

16.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

17.0	AESS10KB366	INSERT
------	-------------	--------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
14	AESS10KB366	Insert	

18.0	AESS10KB266	INSERT
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB266	Insert	
	or NAS1330C3KB266		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D3391025

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	AESS10KB316	INSERT
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB316	Insert	
or NAS1330C3KB316			

20.0	D2646	Aft Cap
------	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	

21.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	

22.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	

23.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	

**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/ R Sikaflex-241/-291 \_\_\_\_\_

Sikaflex expiry date: \_\_\_\_\_

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07.09.26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 29241
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> E	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
? 14.000	+/-0.010	14.000				
? 3.500	+/-0.010					
88.93	+/-0.030	88.93	/			
? 44.995	+/-0.030					
3.200	+/-0.010	3.200	—			
1.526	+0.000/-0.030	1.526	—			
0.200	+/-0.010	0.206	—			
7.500	+/-0.010	7.494	/			
27.750	+/-0.010	27.750	—			
31.750	+/-0.010	31.750	—			
35.250	+/-0.010	35.250	—			
PH 0.400	+/-0.010					
PH Ø0.208	+0.005/-0.001					
3.300	+/-0.010	3.308/3.302/3.305	✓			
0.200	+/-0.010	0.206	—			
3.520	+/-0.010	3.524				
0.687	+0.010/-0.000	0.692	—			
R0.062	+/-0.010	0.062				
Ø0.484	+0.005/-0.001	0.484	—			

<b>Measured by:</b> <i>en</i>	<b>Audited by:</b>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/02/06	<b>Date:</b>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	

**Dart Aerospace Ltd**

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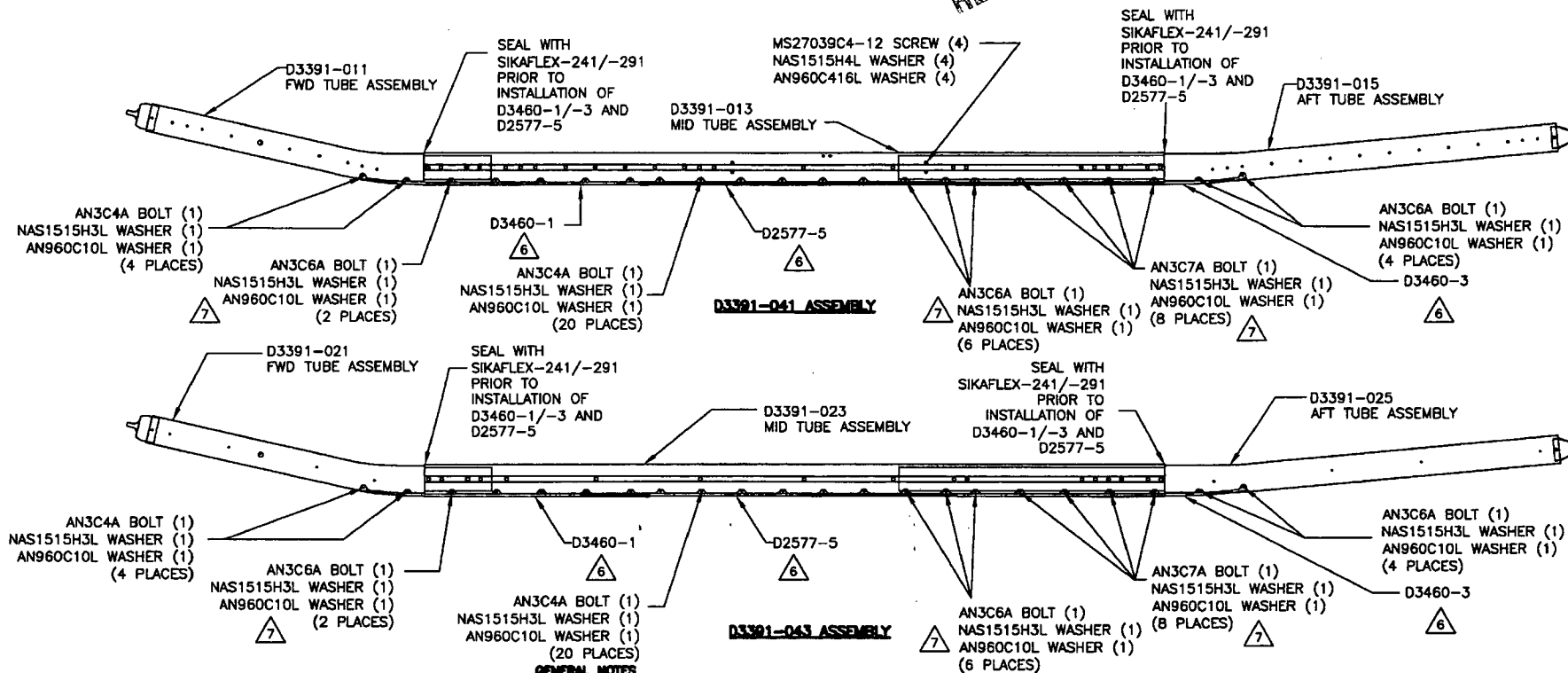
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY



**D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

- GENERAL NOTES**
- 1) ALL DIMENSIONS ARE IN INCHES
  - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
  - 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL "E" SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS.  
C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
  - 6) APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
  - 7) DO NOT TORQUE, HAND TIGHTEN ONLY

D

RELEASED

06-05-03

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E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	06.04.25	TITLE
		412 FLOAT SKIDTUBE
		SCALE
		NTS

**DART** DART AEROSPACE USA, INC.  
FORT HALL, WA

DRAWING NO. D3391  
REV. E  
SHEET 1 OF 5

**Dart Aerospace Ltd**

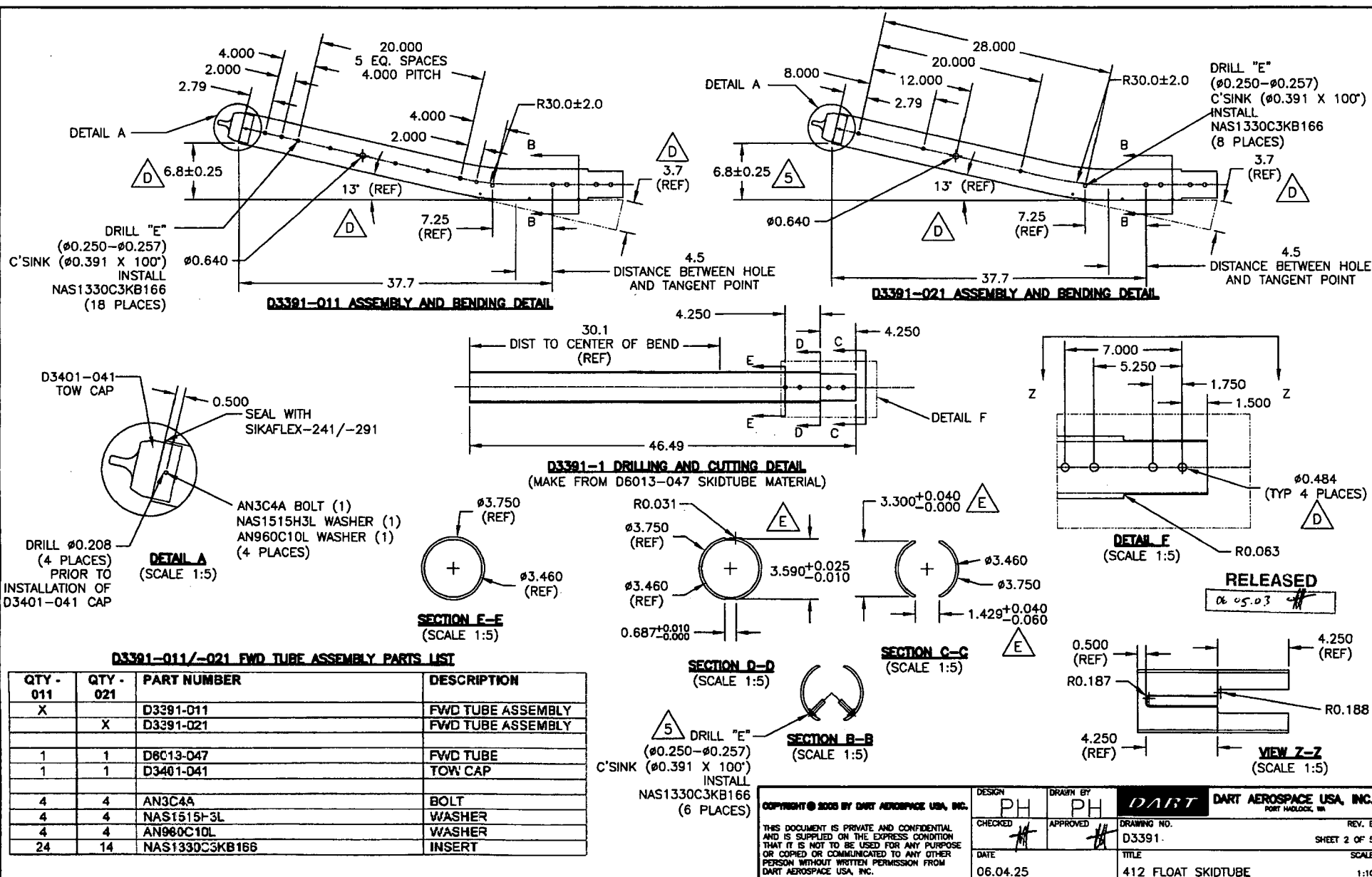
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**Dart Aerospace Ltd**

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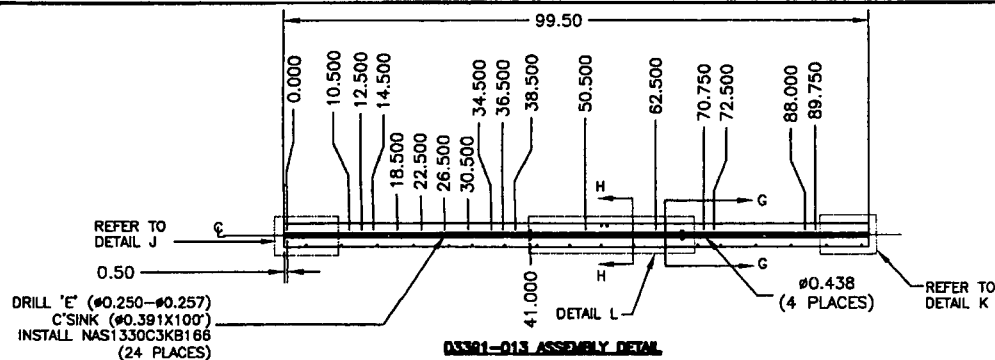
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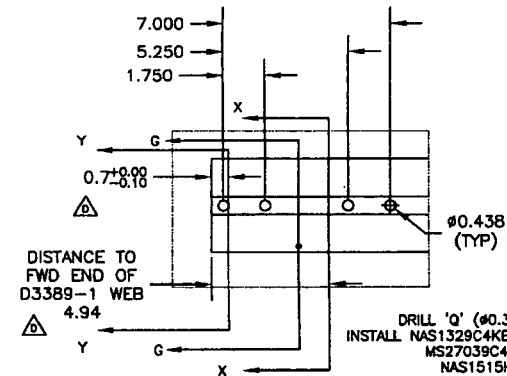
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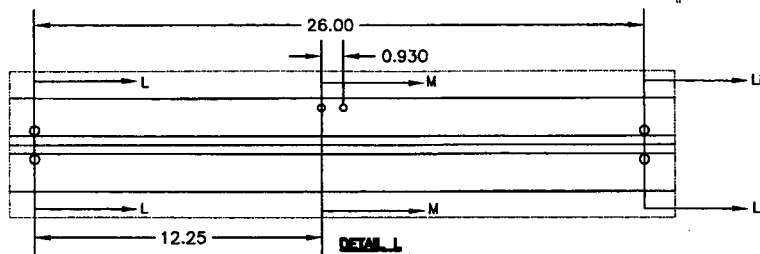


**D3391-013 ASSEMBLY DETAIL**



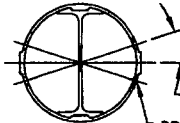
**DETAIL J**  
(SCALE 1:5)

DRILL 'Q' (#0.332-#0.338)  
INSTALL NAS1329C4KB140 INSERT  
MS27039C4-08 SCREW  
NAS1515H4L WASHER  
AN960C416L WASHER  
(TYP 4 PLACES)



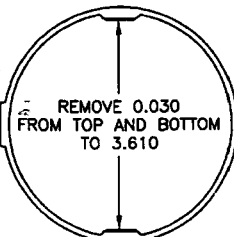
**DETAIL L**  
(SCALE 1:5)

DRILL 'E' (#0.250-#0.257)  
C'SINK (#0.391X100')  
INSTALL NAS1330C3KB116 INSERT  
MS27039C1-09 SCREW  
NAS1515H3L WASHER  
AN960C10L WASHER  
(TYP 4 PLACES)



**SECTION II-II**  
(SCALE 1:4)

**SECTION I-I**  
(SCALE 1:4)



**SECTION X-X**  
(SCALE 1:2)

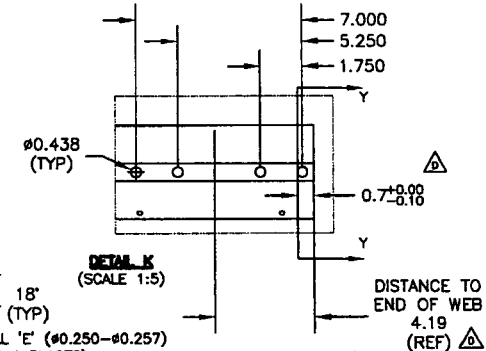
REMOVE 0.225  
FROM TOP AND BOTTOM  
TO 3.800  
(0.7 FROM BOTH ENDS)

**SECTION Y-Y**  
(SCALE 1:4)



**SECTION Q-Q**  
(SCALE 1:4)

**DETAIL K**  
(SCALE 1:5)



**RELEASE**

**D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

**D3391-013/-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

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DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, OH	REV. E
CHECKED #	APPROVED #	DRAWING NO. D3391	SHEET 3 OF 5
DATE 06.04.25		TITLE 412 FLOAT SKIDTUBE	SCALE 1:20

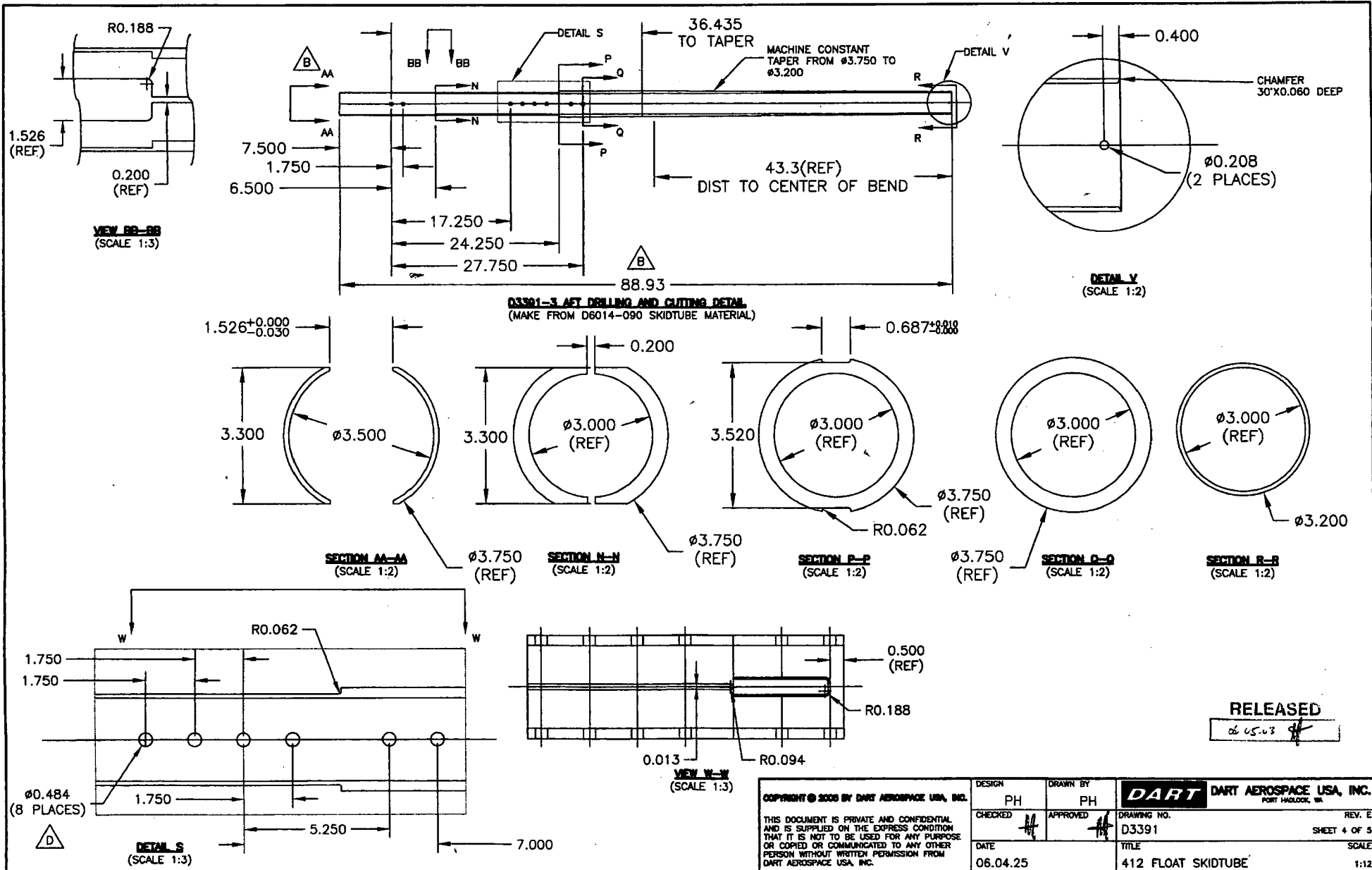
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		CHECKED	APPROVED		SHEET 4 OF 5
		DATE		TITLE	SCALE
		06.04.25		412 FLOAT SKIDTUBE	1:12

0.225

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries